

Work Order ID 101205

Friday, May 03, 2013 2:38:35 PM

101205Ship monday Page 1

Item ID: DSI 9053-011

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Item Name: Basket Hinge Change

Stop ***NS2***

Start Date: 5/3/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/3/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *13-5-03* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSI 9053

Rev N/A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP DSI 9053-011 CHG001

DAS 06 13/5/16

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

*1x**SP 13-5-4*

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

13/5/16

Work Order ID 101205

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101205

Page 2

Item ID: DSI 9053-011

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Basket Hinge Change

Stop ***NS2***

Start Date: 5/3/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/3/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP Dsi9053-
011 Location: _____ PPP Rev: _____

1. 8 13-5-6

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCS 13-05-06

MCS 13-05-06

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
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☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

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Page 1

Work Order ID: 101205
Parent Item: DSI 9053-011
Parent Item Name: Basket Hinge Change

Start Date: 5/3/2013

Required Date: 5/3/2013

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A02.05.15New IssueNG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-12A
Bolt

Purchased

No

120

Each

56.0000

4

4

SP

Location

Loc Qty

Loc Code

GA

6

122407

6

ST351

5

114536

1

123352

4

ST512

45

123759

45

4x

AN3-14A
Bolt

Purchased

No

120

Each

63.0000

6

6

SP

Location

Loc Qty

Loc Code

ST512

63

123759

63

6x

AN4-6A
Bolt

Purchased

No

120

Each

1,875.0000

2

2

SP

Location

Loc Qty

Loc Code

ST514

1875

123355

1875

2x

AN260JD10
Washer

NAS1149D0363J

Purchased

No

120

Each

0.0000

40

40

SP

AN260JD416
Washer

NAS1149D0463J

Purchased

No

120

Each

0.0000

8

8

SP

SP 13-5-6.

Picklist Print

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Page 2

Work Order ID: 101205
Parent Item: DSI 9053-011
Parent Item Name: Basket Hinge Change

Start Date: 5/3/2013

Required Date: 5/3/2013

Start Qty: 1.00

Required Qty: 1.00

~~D2232-0~~

Basket Hinge

Manufactured No

120 Each 6.0000

2 2 SP

Location

Loc Qty

Loc Code

WA

5

98362

5

WA004

1

79472

1

120 Each 35.0000

2 2

~~D2232-3~~

Basket Hinge

Manufactured No

Location

Loc Qty

Loc Code

WA

3

97261

3

WA004

32

75581

2

98040

10

98473

20

120 Each 4.301.0000

10 10 SP 13-5-6

MS210421.3

Nut

Purchased No

Location

Loc Qty

Loc Code

FP001

3

122141

3

GA

71

122452

71

ST314

268

117885

32

119017

55

119075

138

123265

43

ST506

3959

123900

974

124291

2985

10x

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 101205

Parent Item: DSI 9053-011

Parent Item Name: Basket Hinge Change

Start Date: 5/3/2013

Required Date: 5/3/2013

Start Qty: 1.00

Required Qty: 1.00

MS210421-4

Nut

Purchased

No

110

Each

497.0000

2

2

Location

Loc Qty

Loc Code

FP001

50

122452

38

8182

12

ST518

447

124231 ✓

447

2

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Shop Packet Print

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DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. DSI 9053	REV. B SHEET 1 OF 2
DATE 01.04.16		TITLE BASKET HINGE CHANGE	SCALE NTS
A	96.11.06	NEW ISSUE	
B	01.04.16	REDRAWN	

13-516
REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION DRAWING D205-541 REV. D
(REF. CANADIAN STC: SH96-120, FAA STC: SR00696NY)
AND INSTALLATION DRAWING D350-607 REV. E
(REF. CANADIAN STC: SH94-14, FAA STC: SR00213NY)

IF THE D2569 HINGE IS BEING REPLACED, THE PARTS LIST OF D205-541 REV. D (D205-541-011 CHG 003) / D350-607 REV. E (D350-607-041/-042 CHG 004) SHOULD BE AMENDED AS FOLLOWS:

REPLACE:

Qty	Part Number	Description
1	D2569	HINGE
36	AD64ABSLF	RIVET

WITH:

Qty	Part Number	Description
X	DSI 9053-011	HINGE CHANGE KIT
2	D2232-1	HINGE PLATE
2	D2232-3	HINGE PLATE
4	AN3-12A	BOLT
6	AN3-14A	BOLT
2	AN4-6A	BOLT
40	AN960JD10	WASHER*
8	AN960JD416	WASHER*
10	MS21042L3	NUT (OR MS21042-3)
2	MS21042L4	NUT (OR MS21042-4)

* NOTE: IT IS ALSO ACCEPTABLE TO REPLACE THE WASHERS THAT ARE USED AS SPACERS WITH A SINGLE ALUMINUM SPACER OF APPROPRIATE LENGTH (SEE PAGE 2).

REPLACE D2569 HINGE AS FOLLOWS:

- 1) REMOVE EXISTING HINGE BY DRILLING OUT AD64ABSLF RIVETS. PLUG HOLES WITH RIVETS IF DESIRED.
- 2) DRILL HOLES IN D2232-1/-3 HINGE PLATES AS SHOWN ON PAGE 2.
- 3) LOCATE D2232-1 HINGE PLATE ON D2512 BASKET LID ASSEMBLY. REMOVE MESH AS REQUIRED SO THAT D2232-1 HINGE PLATE SITS FLUSH ON D2512 BASKET LID ASSEMBLY. TRANSFER DRILL Ø0.191 HOLES. INSTALL D2232-1 HINGE PLATE WITH HARDWARE AS SHOWN ON PAGE 2. REPEAT AT OTHER END OF BASKET.
- 4) LOCATE POSITION OF D2232-3 HINGE PLATE FROM D2232-1 HINGE PLATE BY ENSURING Ø0.257 HOLE IS ALIGNED. REMOVE MESH AS REQUIRED TO ENSURE THAT D2232-3 HINGE PLATE AND ATTACHMENT HARDWARE SITS FLUSH AGAINST D2206/D2221 BASKET BASE ASSEMBLY. TRANSFER DRILL Ø0.191 HOLES. INSTALL D2232-3 HINGE PLATE WITH HARDWARE AS SHOWN ON PAGE 2. REPEAT AT OTHER END OF BASKET.
- 5) TOUCH UP PAINT AS REQUIRED.

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Work Order ID 101205

Friday, May 03, 2013 2:38:35 PM

101205

chip Monday Page 1

Item ID: DSI 9053-011

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Basket Hinge Change

Stop

NS2

Start Date: 5/3/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/3/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *WUX*

Date: *12-5-03* Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequencer ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9053

Rev N/A

MCS 13-05-06

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP DSI 9053-011 CHG001

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

~~DSI 9053-013~~
~~3099289~~

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
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<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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